

# Work Order ID 56460

February 24, 2010 9:19:06 AM

Page 1

**PRELIMINARY ISSUE**

Item ID: D4007-1

Revision ID:

Item Name: Support

Start Date: 2/24/10 Start Qty: 4.00

Required Date: 2/26/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4007

~~APRELIM~~ Rev. A

100

Waterjet

FLOW CNC Waterjet

0.00

0.00

Memo

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

2-Deburr if necessary

Receive & Inspect

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

PO 11416

BS 10-2-24  
(H)

Pu 1/3/19

(4)

# Work Order ID 56460

February 24, 2010 9:19:06 AM

Page 2

Item ID: D4007-1

Accept

Revision ID:

Item Name: Support

Setup Start

Stop

Start Date: 2/24/10 Start Qty: 4.00

Required Date: 2/26/10 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

~~QC8- Inspect parts second check~~

0.00



QC

QC6 inspect parts + mat. cert.

Quality Control

Memo

8/6/23 to present daily

0.00

QC APPROVAL

*[Signature]*

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

N/A  
*[Signature]*  
10.04.13.

# Work Order ID 56460

February 24, 2010 9:19:06 AM



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Item ID: D4007-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/24/10 Start Qty: 4.00



Required Date: 2/26/10 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

POSITIVE RECALL

EFFECTIVE 10/06/15

AUTH [Signature]

RELEASED [Signature]

DATE 10-06-10 copy 4

10/06/15 [Signature]

10-6-15 [Signature]

# Picklist Print

February 24, 2010 9:19:05 AM

Page 1

Work Order ID: 56460



Parent Item: D4007-1



Parent Item Name: Support

Start Date: 2/24/10

Required Date: 2/26/10

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	146.1602	1.3263			



2024 T3 .063 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT

146.1601505

105916

1.09

110980

5.4854

111787

12.2847505

113866

69.3

113867

56

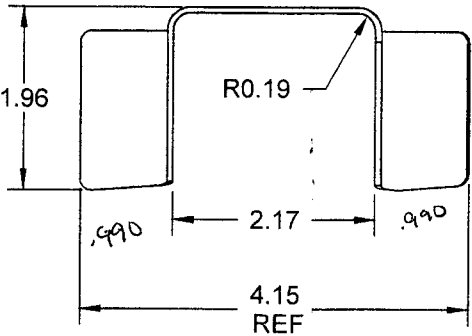
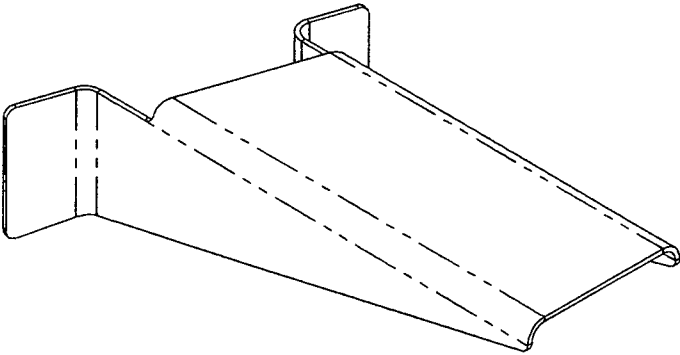
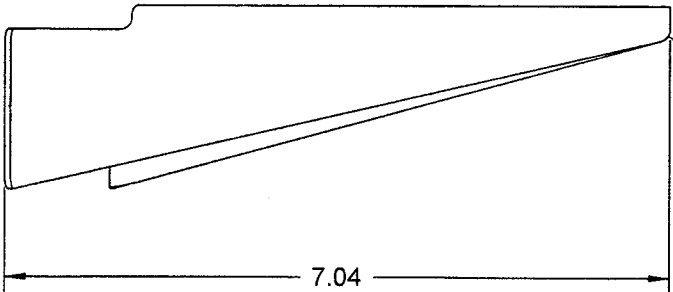
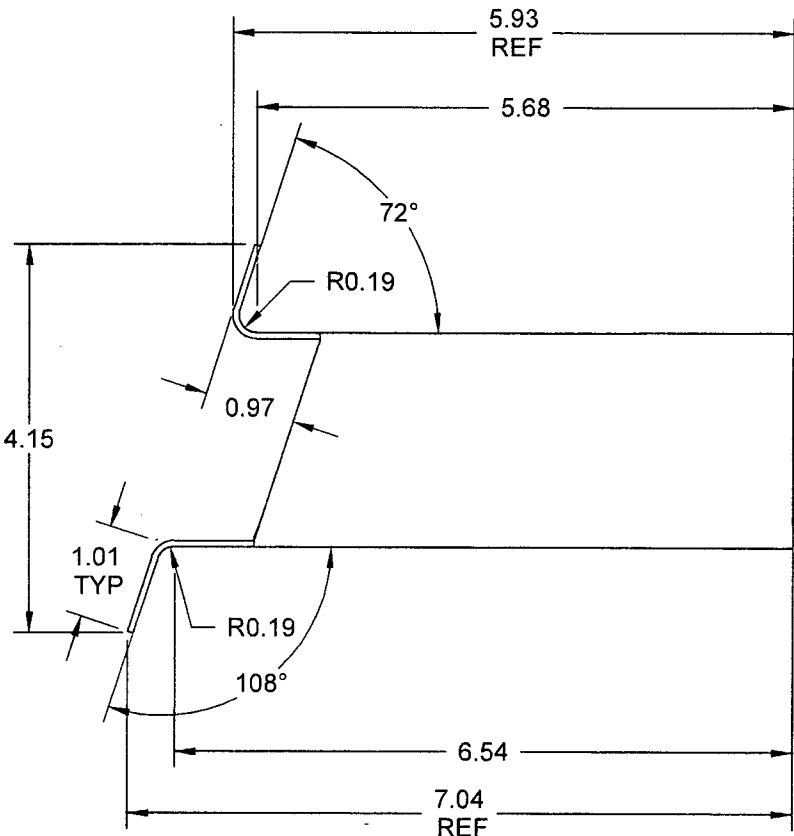
19059

2

D4007-1P

W

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-1	JCA-M47-2-02



See Rev A

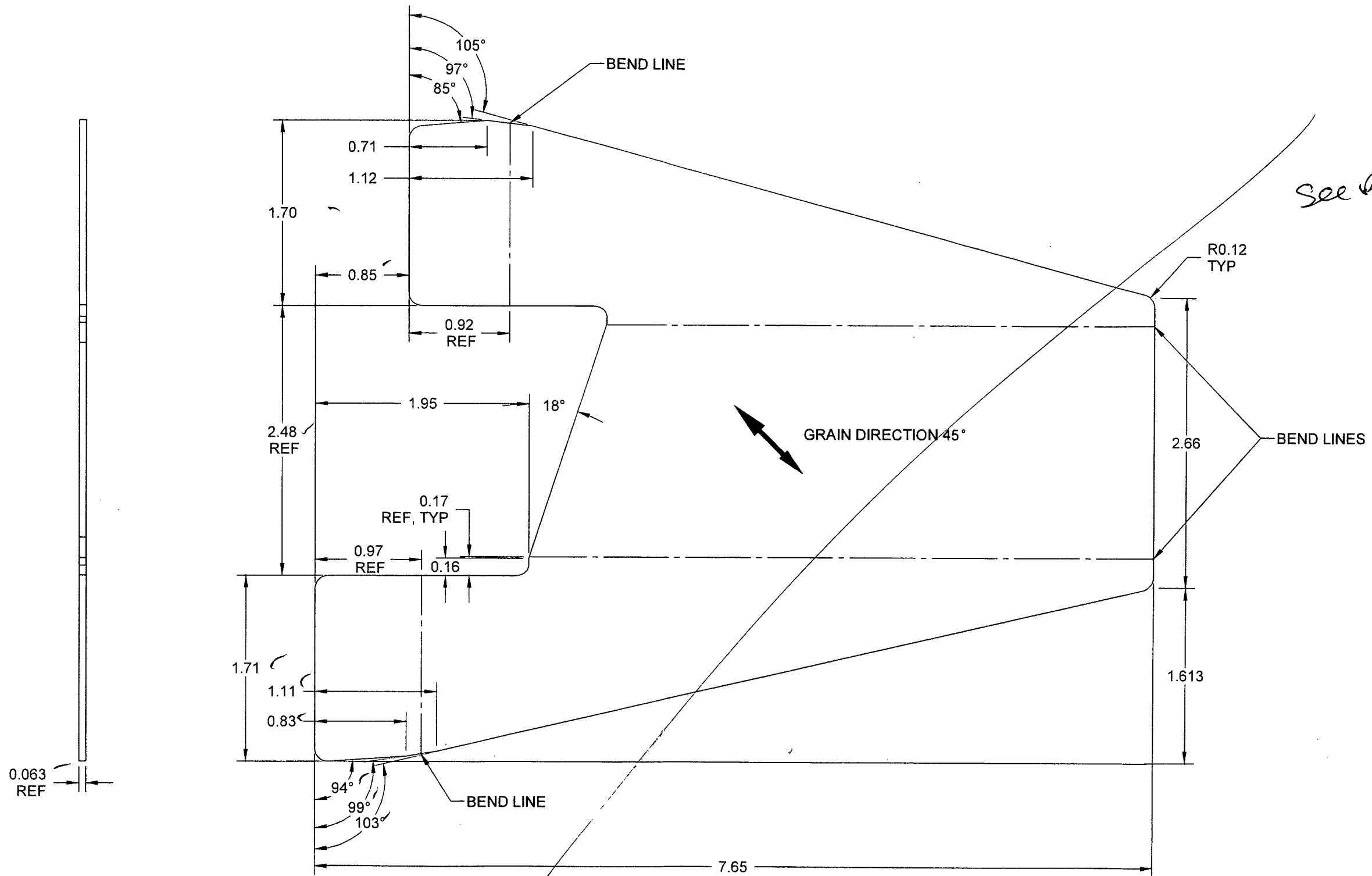
**D4007-1 SUPPORT**

**PRELIMINARY ISSUE**

09.10.20

- NOTES:**
- 1) MATERIAL: MADE FROM D4007-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-1" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.17 lbs

PA1	NEW ISSUE	BY	09.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4007</b> TITLE <b>SUPPORT</b> SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. PA1	SHEET 1 OF 5
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.20		



# NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

**D4007-1F FLAT PATTERN**

**PRELIMINARY ISSUE**

09.10.20

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 09.10.20

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. PA1  
**D4007** SHEET 2 OF 5  
TITLE SCALE  
**SUPPORT** NTS

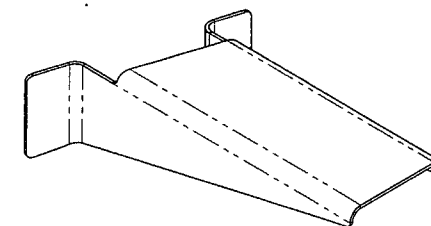
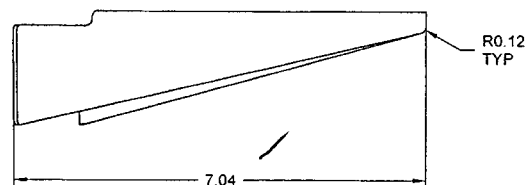
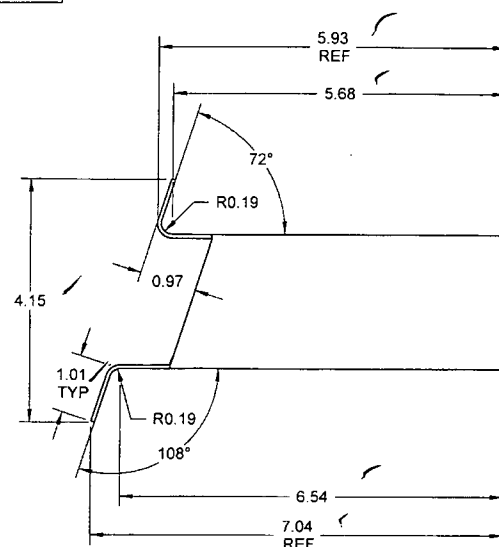
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DART AEROSPACE  
PART NUMBER

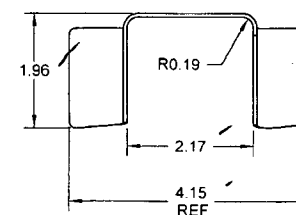
D4007-1

JOHN CAMERON AVIATION  
PART NUMBER

JCA-M47-2-02



W1056460

**D4007-1 TOP SUPPORT BRACKET****NOTES:**

- 1) MATERIAL: MADE FROM D4007-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.17 lbs

**RELEASED**  
2010-05-05

A	NEW ISSUE		10.02.05
REV.		DESCRIPTION	BY DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			DRAWING NO. REV. A
MFG. APPR.			D4007 SHEET 1 OF 8
APPROVED			TITLE SCALE
DE APPR.			SUPPORT NTS
DATE	10.02.05		
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11416

Purchase Order Date 2/24/10

PO Print Date 2/24/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 630 4877	Requisition Nbr	
Vendor Fax	514 630 4849	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4005-3P	Fwd Restaint Beam	2/25/10 3/12 Yes	4.00 Each	Purolator ground	\$99.0000	\$396.00
		Special Inst:	As per DWG: D4005 Rev: PA1 B# 55835				
2	D4007-1P	Support	2/25/10 3/12 Yes	4.00 Each	Purolator ground	\$80.0000	\$320.00
		Special Inst:	As per DWG: D4007 Rev: PA1 B#56460				
PO Total:							\$716.00

PO Instructions: GFI QUOTE# GFI 2087

Change Nbr: 1

Change Date: 2/24/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



180 AVENUE LABROSSE  
POINT-CLAIRE, QC, CANADA H9R 1A1  
TÉL: (514) 630-4877 - FAX: (514) 630-4849

Il est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO. - MO.	AN. - YR		
16	03	10	0434431	1/1




NDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA		
DART	GFI-0299	0211071	PO11416		
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION			
4	D4007-1P	SUPPORT  CERTIFICATE OF CONFORMANCE REQ			
MFG. JOB# <u>JO211071-001</u> QTY <u>4</u>					
					
EXPÉDITEUR SHIPPER		N° DE BON DE LIVRAISON SHIPPING MEMO NO.			

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0211071 SHIPPING MEMO 0434431

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUES
--	4 PCS	PO11416	D4007-1P		SUPPORT	PA1

MATERIAL AL 2024-T3 SUPPLIED BY SAMUEL / KAISER ALUMINUM MAT. REL. NO. 419327A2

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER J0211071-001 (4 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 17 MARCH 2010

G.F.I. Q.C. REP. Arthur Hanley





LES METAUX SPECIALISES SAMUEL  
21525 CLARK-GRAHAM  
BAIE D'URFE, QUEBEC, CANADA  
H9X 3T5

No 001468863



(514) 457-3399

FAX (514) 457-9393

PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME  
CASTERO TRANSPORT

CAMION/TRUCK  
099

NOM DE LA BRANCHE/SALES BRANCH NAME  
LES METAUX SPECIALISES SAMUEL

DATE D'EXP/DATE OF SHIPMENT  
9/14/09

**VENDU À/SOLD TO:**

GFI DIVISION OF THOMAS & BETTS, LIMITED  
180 AVENUE LABROSSE  
POINTE CLAIRE  
POINTE-CLAIRE  
QC  
H9R1A1 (514) 630-4877

**EXPÉDIÉ À/SHIP TO: TÀB: DEST**

G.F.I. INC  
180 AVENUE LABROSSE  
POINTE-CLAIRE  
QC  
H9R1A1 CA (210678-00001)

N° COMMANDE  
N° ITEM  
489556-01

**DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT**

#Comm du client: 0075894  
1 PCS FEUILLES ALUMINIUM 2024 T3  
.0630"x48"x144"

Cert/Test: TRUCK  
43 LVR

Description	Art	Pd ca	Qté	#Étiq	Vendeur
#Étiq mln	#À soul			Étiq princ	#Coul
	1	48.000	43	4564255	017
1297052				D851930	419327A2
Total:	1	48.000	43		

Poids total:

#Total paquets: 1

43 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ  
LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ  
CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX  
SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS  
RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

DATE 11-3-09  
PAM BOOTH  
ADMINISTRATION  
INSPECTION  
7  
SAMUEL

NIR: R-539477-1

PRÉPAYÉ PAR CHARGES	<input checked="" type="checkbox"/> PORT PAYÉ/PREPAY <input type="checkbox"/> PORT D'COLLECT	INST VOITURIER/DRIVER INSTRUCTIONS	REÇU PAR/RECEIVED BY
EXPÉDITEUR/DISPATCHER		VOITURIER/DRIVER	

1. ORIGINAL - NON NÉGOCIABLE (CE CONNaissement doit être signé par l'expéditeur et le voiturier)

## SHIP TO:

SAMUEL BAIE D'URFE  
21525 CLARK-GRAHAM  
BAIE D'URFE, PQ, CA H9X3T5

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number

4146676

## SOLD TO:

SAMUEL LAVAL  
2225 FRANCIS HUGHES  
LAVAL, PQ, CA H7S1N5

CUSTOMER PO NUMBER: N21479		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID: 101411/2		GOVT CONTRACT NUMBER:	
KAISER ORDER NO: 1074833	LINE ITEM: 3	SHIP DATE: 11-NOV-2008	ALLOY: 2024	CLAD: BARE	TEMPER: T3	PRODUCT DESCRIPTION: MILL FINISH SHEET			
WEIGHT SHIPPED: 3180 LB	QUANTITY: 71 PCS EST.	B/L NUMBER: 2020211	GAGE: 0.0630 IN	WIDTH: 48.000 IN		LENGTH: 144.000 IN			

8065123

### Certified Specifications

AMS 4037/RevN  
CMMP 019/RevD

AMS-QQ-A-250/4/RevA  
CMMP 025/RevR

ASTM B 209/Rev07

Test Code: 1504

### Test Results

Lot: 419327A2 Cast 443

Drop 13

Ingot 3

(ASTM E8/B557)

Tensile: Temper  
T3Dir / # Tests  
LT / 2 (Min:Max)

Ultimate KSI (MPA)  
67.4 : 67.6  
(465 : 466)

Yield KSI (MPA)  
45.0 : 45.1  
(310 : 311)

Elongation %  
17.1 : 19.0

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	TOT	OTHER
Actual	0.09	0.25	4.4	0.58	1.3	0.01	0.12	0.02	0.01	0.01		0.03

### ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

### TEST NOTES

2024-T351 plate 3.001-4.000" thick, if ultrasonically  
inspected, meets requirements of CMMP025 per SDR  
CMMP025-KaiserT-2.

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

**CERTIFIED TEST REPORT**

Serial Number  
4146676

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

**BILL POYNOR, LABORATORIES SUPERVISOR**

*Bill Poy*